

Work Order ID 52654-1

October 5, 2009 2:52:58 PM



Page 1

Item ID: D3934-041

Accept

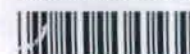


Setup Start



Revision ID: A

Stop



Item Name: Clip Assembly

Start Date: 06/10/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: *BS*

Date: *09-10-5*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3934

RevA

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3934

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

m-l 09/10/13

32x

32

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-10-8

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Item ID: D3934-041	Accept		Setup	Start	
Revision ID: A				Stop	
Item Name: Clip Assembly					
Start Date: 06/10/2009	Start Qty: 10.00		Cust Item ID:		
Required Date: 13/10/2009	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				count (x32)	/		
130 Brake NC Brake NC	1- Bend as per dwg D3934 Memo	0.00 0.00				32	/		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				count (x32)	/		

27 5021013

83 09/10/15

27 5021015

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Item ID: D3934-041
Revision ID: A
Item Name: Clip Assembly

Accept



Setup Start



Stop



Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10/5/09 2:28

u 9.10.27

Picklist Print

Page 1

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Work Order ID: 52654

Parent Item: D3934-041RevA

Parent Item Name: Clip Assembly


Comments:

Start Date: 06/10/2009

Required Date: 13/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			150	sf	183.2904	0.2211	17075		

B910-8

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	183.2904474	
110076	31.73	
111571	12.1938474	
112567	139.3666	

110076

MS21075L3



Nutplate

Purchased

No

150

Each

131.0000

10.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	131	
109068	12	
109371	39	
110704	37	
111477	2	
112640	20	
112690	21	

09/10/26

M112991

13x

Picklist Print

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Work Order ID: 52654



Parent Item: D3934-041RevA



Parent Item Name: Clip Assembly

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20426AD3-3

Purchased

No

100

Each

6,899.000

20.0000



Rivet

Ep 509/10/26

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6899

1563

0

19099

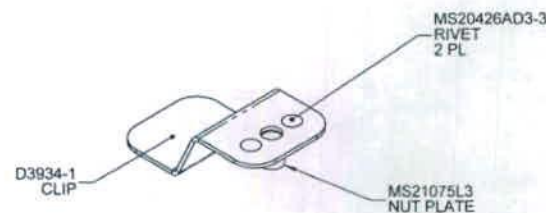
4776

7681

2123

26

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-3	RIVET



D3934-041 CLIP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52654

RELEASED
09/05/03

NOTES:

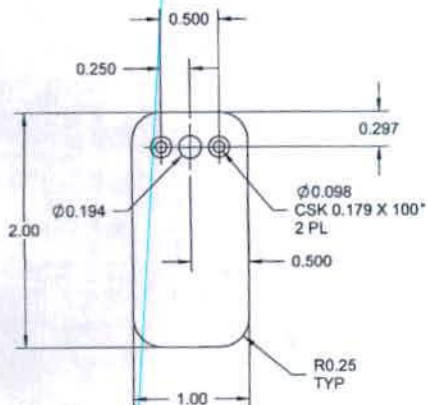
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	PH	09.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

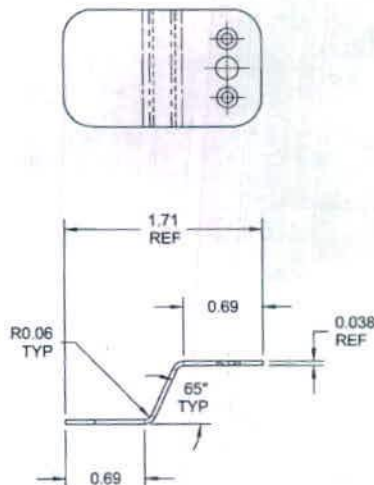
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3934 REV. A
TITLE CLIP ASSEMBLY SCALE NTS
SHEET 1 OF 2

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D3934-1F FLAT PATTERN (1)



D3934-1 CLIP
(MAKE FROM D3934-1F)



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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52654



RELEASED
09/05/05

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	REV	DART AEROSPACE LTD	
DRAWN	REV	HAWKESBURY, ONTARIO, CANADA	
CHECKED	REV	DRAWING NO.	REV. A
MFG. APPR.	REV	D3934	SHEET 2 OF 2
APPROVED	REV	TITLE	SCALE
DE APPR.	REV	CLIP ASSEMBLY	NTS
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